



**Work Order ID 69759**

Wednesday, May 18, 2011 1:01:12 PM



Page 1

**Item ID:** D3535-39

Accept



Setup Start



**Revision ID:**

**Item Name:** Wearshoe

Stop



**Start Date:** 5/18/2011 **Start Qty:** 16.00



**Cust Item ID:**

**Required Date:** 5/23/2011 **Req'd Qty:** 16.00



**Customer:**

**Reference:**

**Approvals:** Process Plan: *PP*

Date: *11-05-16*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3535	Rev B								

100

0.00



FLOW WATER JET

Waterjet

**Memo**

0.00

FLOW CNC Waterjet

*3G4 - 040*

I-Cut as per Dwg D3535

Dwg Rev: *B*

Prog Rev: *R*

Deburr if necessary

*B11-5-31*

(13)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



**Memo**

0.00

Quality Control

*B11-5-31*

120

QC8- Inspect parts - second check

0.00



**Memo**

0.00

Quality Control

*8 w/loc 01*

(x13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Work Order ID 69759



Page 2

Wednesday, May 18, 2011 1:01:12 PM

Item ID: D3535-39

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/18/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



NC BRAKE

0.00

(13)

Brake NC

Memo

0.00

Brake NC

Deburr if necessary □ Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. □ Identify as D3535-41 □ Form Joggle on brake using Jig DT8158 as per Dwg D3535

S vlo6/02

140



QC5- Inspect part completeness to step on W/O

0.00

(43)

QC

Memo

0.00

Quality Control

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

13x / m-f 11/06/06

Powdercoat

Powder Coating

Memo

START TIME:

7:30

0.00

OVEN TEMPERATURE:

320°F

8:00

M 11/06/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 69759**

Page 3

Wednesday, May 18, 2011 1:01:12 PM

Item ID: D3535-39

Accept



Setup

Start



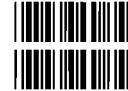
Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/18/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

13 BK 11-6-6

Quality Control

170

Identify as per dwg &amp; Stock Location: FD-19

0.00



Packaging

Memo

0.00

13 BK 11-6-6.

180

QC2I- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/07/06

Quality Control

MF  
11-06-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

Wednesday, May 18, 2011 1:01:18 PM

Page 1

Work Order ID: 69759



Parent Item: D3535-39



Parent Item Name: Wearshoe

Start Date: 5/18/2011

Required Date: 5/23/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	80.7000	0.951	16.01684 		tB 11-5-3 /	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	80.7	
116623	0.2	
117550	80.5	117550

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	69759
Description: Wearshoe	Part Number:	D3535-39
Inspection Dwg: D3535 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	✓		T B01	
32.775	+/-0.010	32.775	✓		T	
29.275	+/-0.010	29.275	✓		T	
25.775	+/-0.010	25.775	✓		T	
23.250	+/-0.010	23.250	✓		T	
19.750	+/-0.010	19.750	✓		T	
17.750	+/-0.010	17.750	✓		T	
14.250	+/-0.010	14.250	✓		T	
9.500	+/-0.010	9.500	✗		T	
4.750	+/-0.010	4.750	✗		T	
2.000	+/-0.010	2.000	✗		V B02	
5.00	+/-0.030	5.00	✓		T	
9.00	+/-0.030	9.00	✗		T	
28.00	+/-0.030	28.00	✗		T	
Ø0.188	+0.005/-0.001	.191	✗		V	
1.885	+/-0.010	1.888	✗		V	
0.300	+/-0.010	.302	✗		V	
0.300	+/-0.010	.303	✗		V	
0.038	+/-0.010	.035	✗		V	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-5-18	Date:	11/06/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	Z

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

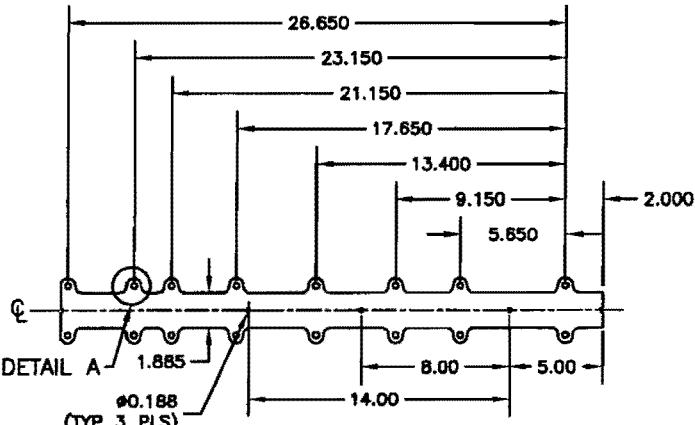
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SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

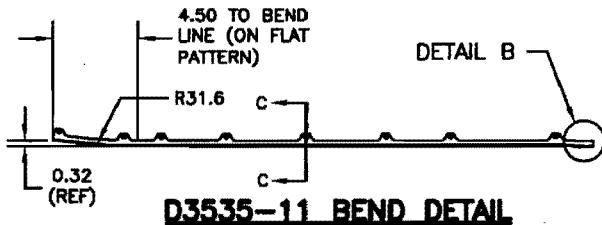
NO. *69759*

*PL11-05-18*

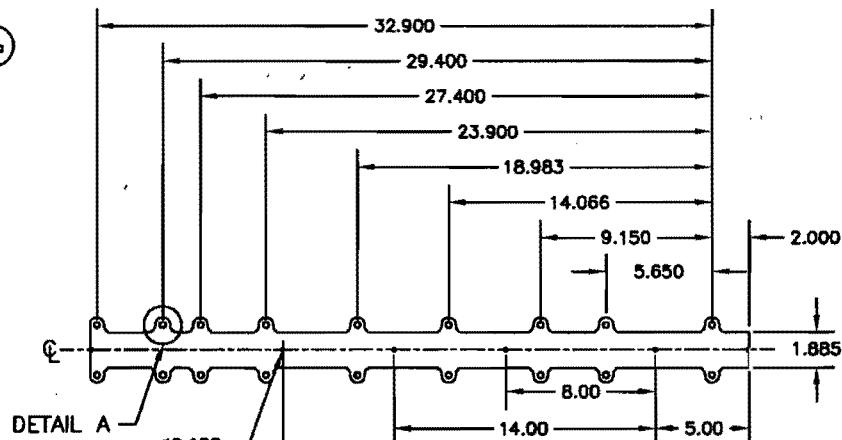
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*57-04-24*



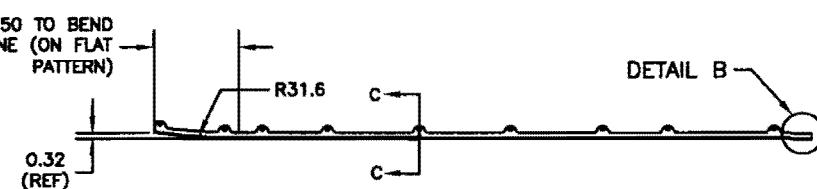
**D3535-11F FLAT PATTERN**



**D3535-11 BEND DETAIL**



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

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- NOTES**
- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
  - FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
  - PART IS SYMMETRICAL ABOUT C
  - TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
  - ALL DIMENSIONS ARE IN INCHES
  - BREAK ALL SHARP EDGES TO 0.010 MAX
  - IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
  - SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
<b>CB</b>	<b>PH</b>	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>PH</i>	<i>PH</i>	D3535
07.04.17		WEARSHOE
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

REV. B  
SHEET 1 OF 7  
SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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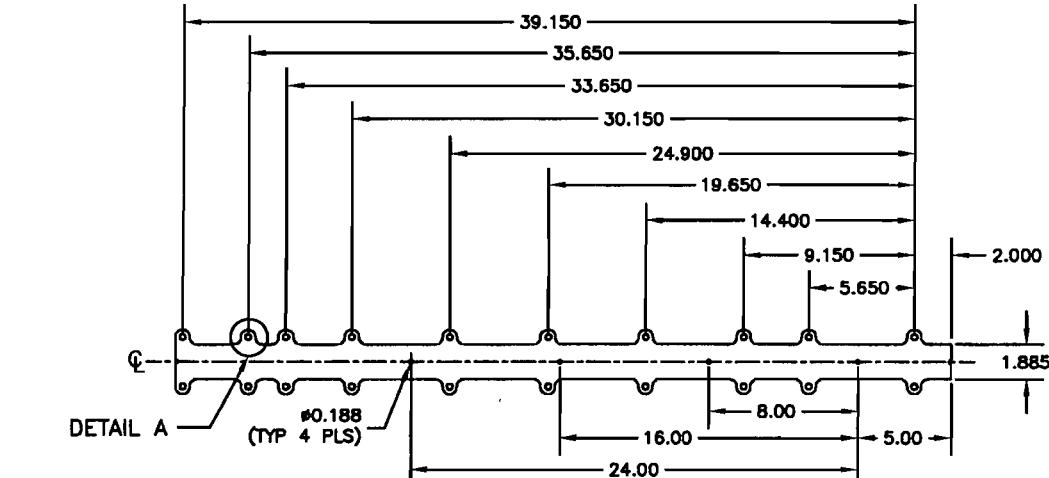
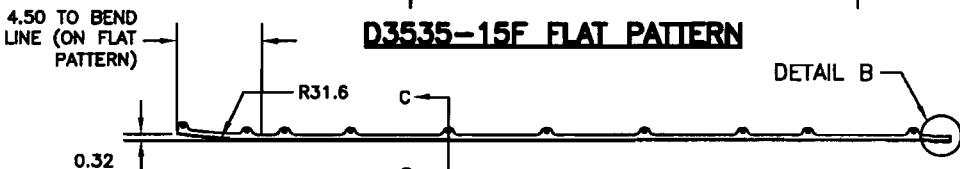
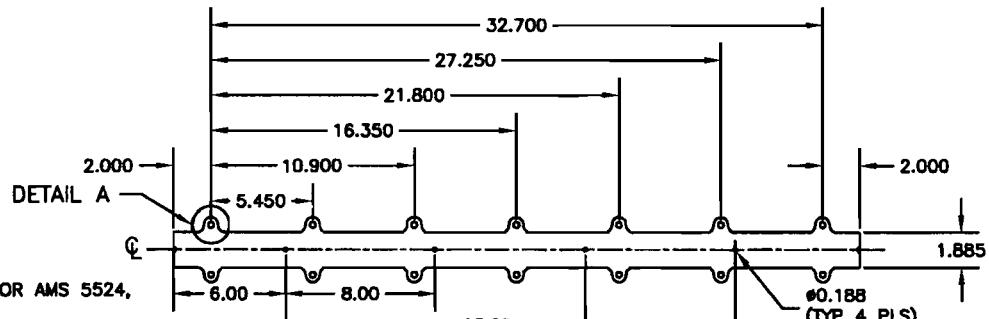
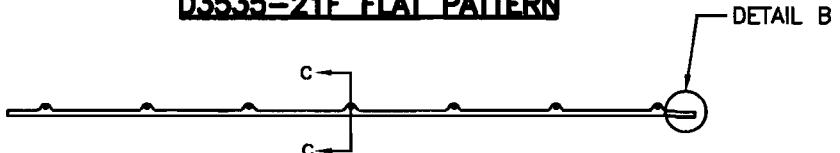
NOTE: Date & initial all entries

**DART**

RELEASED

07.04.17

w/CG9759

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

DESIGN CB	DRAWN BY <i>AT</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE
		REV. B
		SHEET 2 OF 7
		SCALE 1:10

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

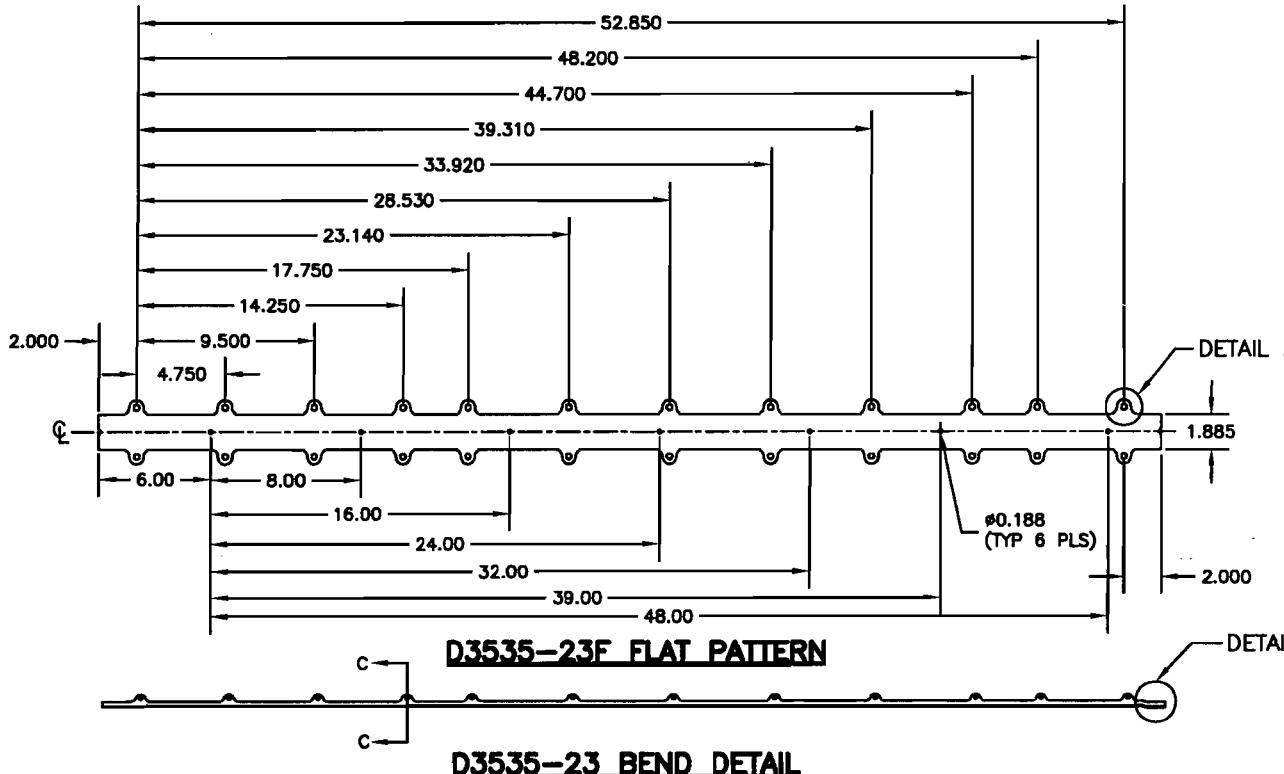
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

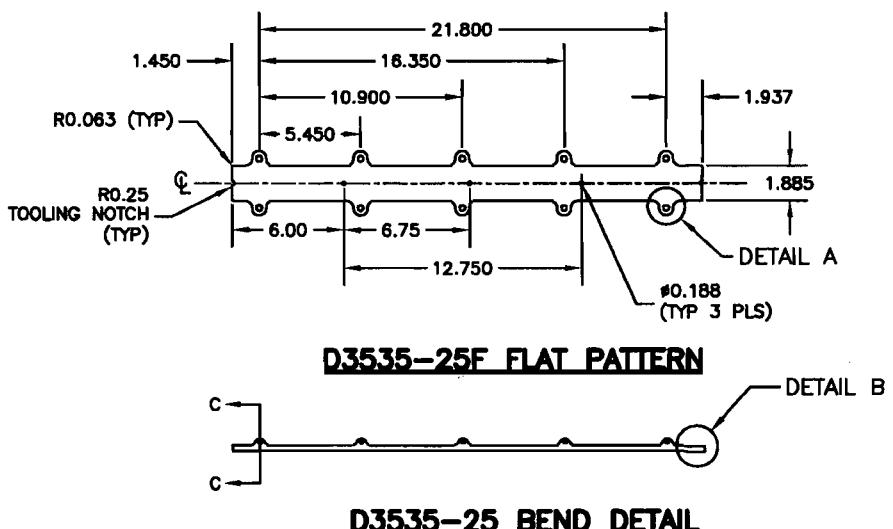
**DART**

DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>H</b>	APPROVED <b>H</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>		TITLE <b>WEARSHOE</b>

REV. B  
SHEET 3 OF 7  
SCALE  
1:10



- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.  
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

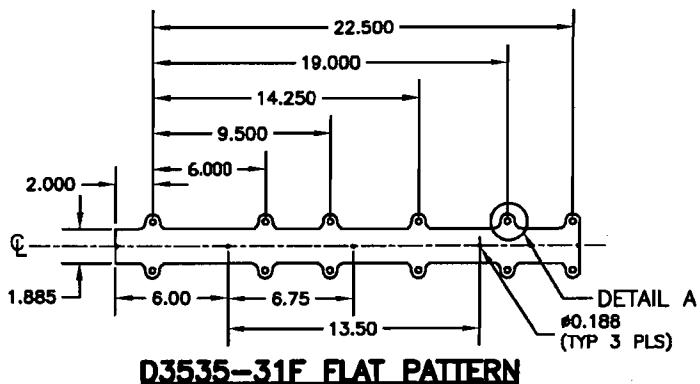
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RELEASER

07.04.24

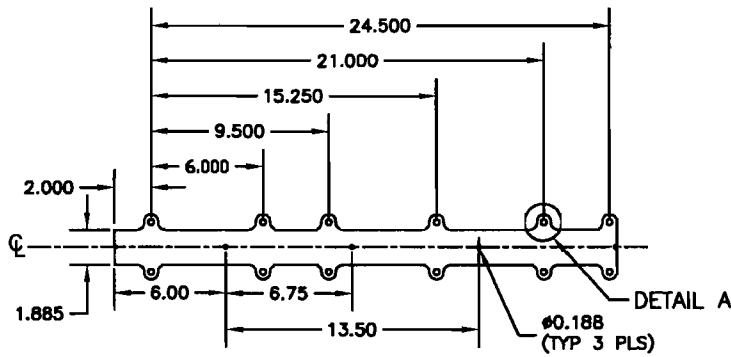


## **D3535-31F FLAT PATTERN**



**D3535-31 BEND DETAIL**

K 100A?59



## **D3535-33F FLAT PATTERN**



**D3535-33 BEND DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
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DESIGN		C B	DRAWN BY	RH	DART AEROSPACE USA, INC.	
CHECKED		<del>  </del>	APPROVED	<del>  </del>	PORT HADLOCK, WA	
DATE		07.04.17	DRAWING NO.	D3535	REV. B	
TITLE		WEARSHOE	SHEET 4 OF 7		SCALE	1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

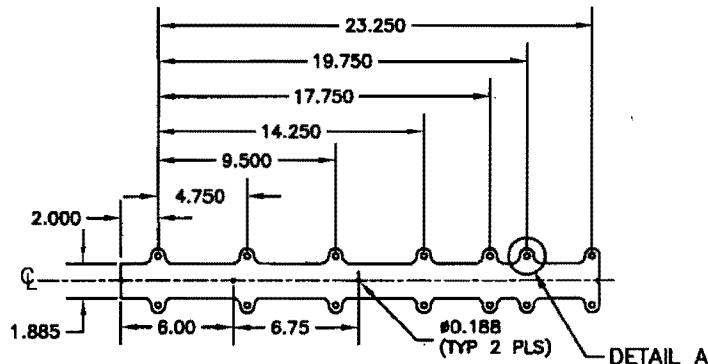
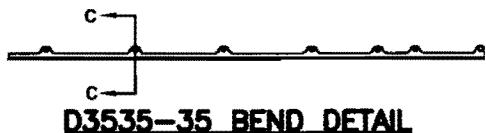
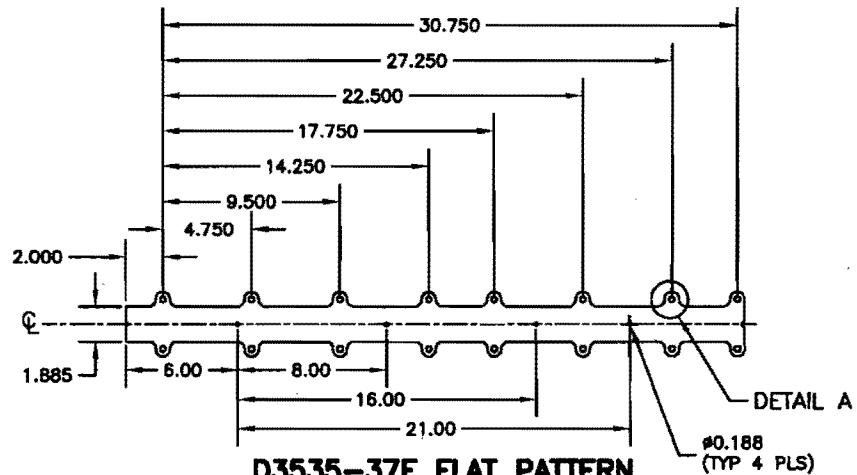
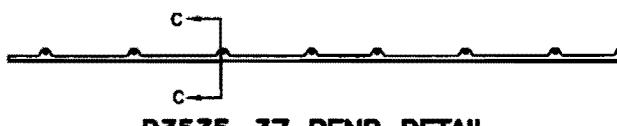
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <b>C.B</b>	DRAWN BY <b>RH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>M</b>	APPROVED <b>M</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TIME <b>10:00 AM 07/05/17</b>	SCALE <b>1:10</b>

RELEASED  
07.04.17**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

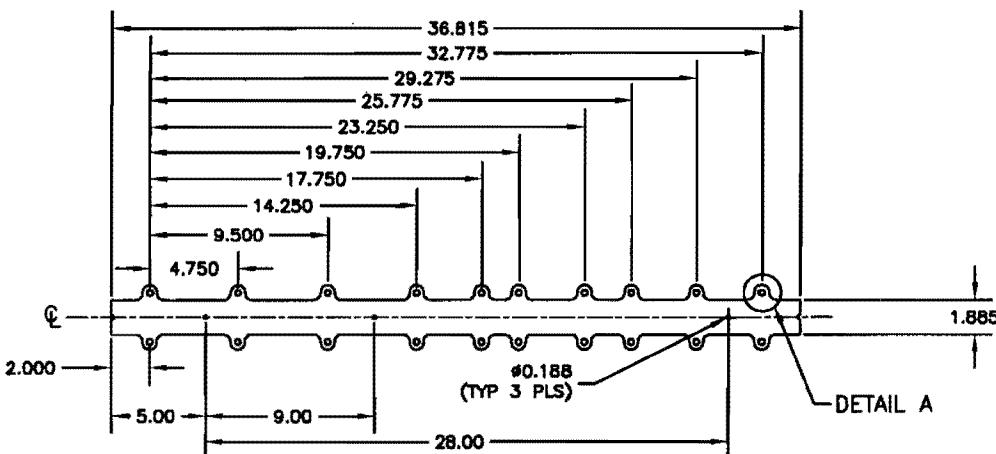
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**C**



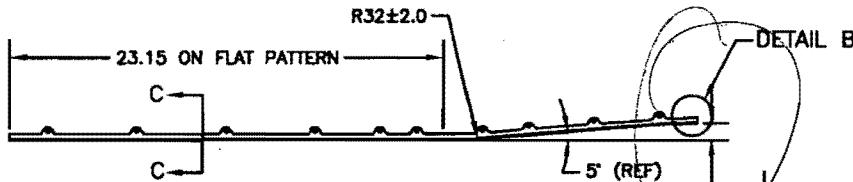
**D3535-39F FLAT PATTERN**

**RELEASED**

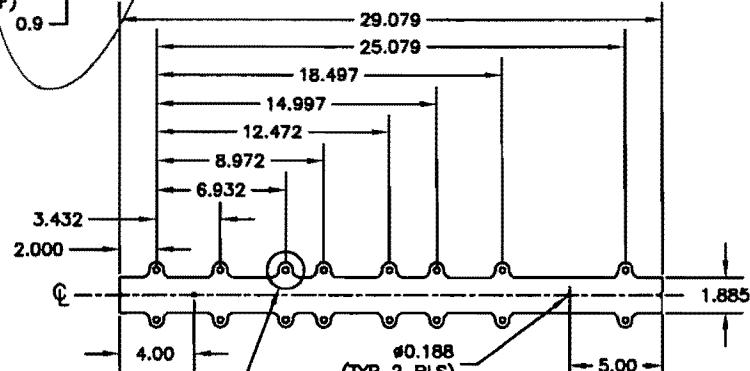
07.04.24

**DART**

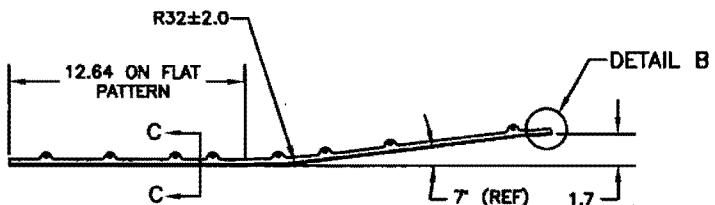
✓ 6/6/159



**D3535-39 BEND DETAIL**



**D3535-41F FLAT PATTERN**



**D3535-41 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	RH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
✓	✓	D3535
DATE		TITLE
07.04.17		WEARSHOE
REV. B	SHEET 6 OF 7	SCALE
		1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

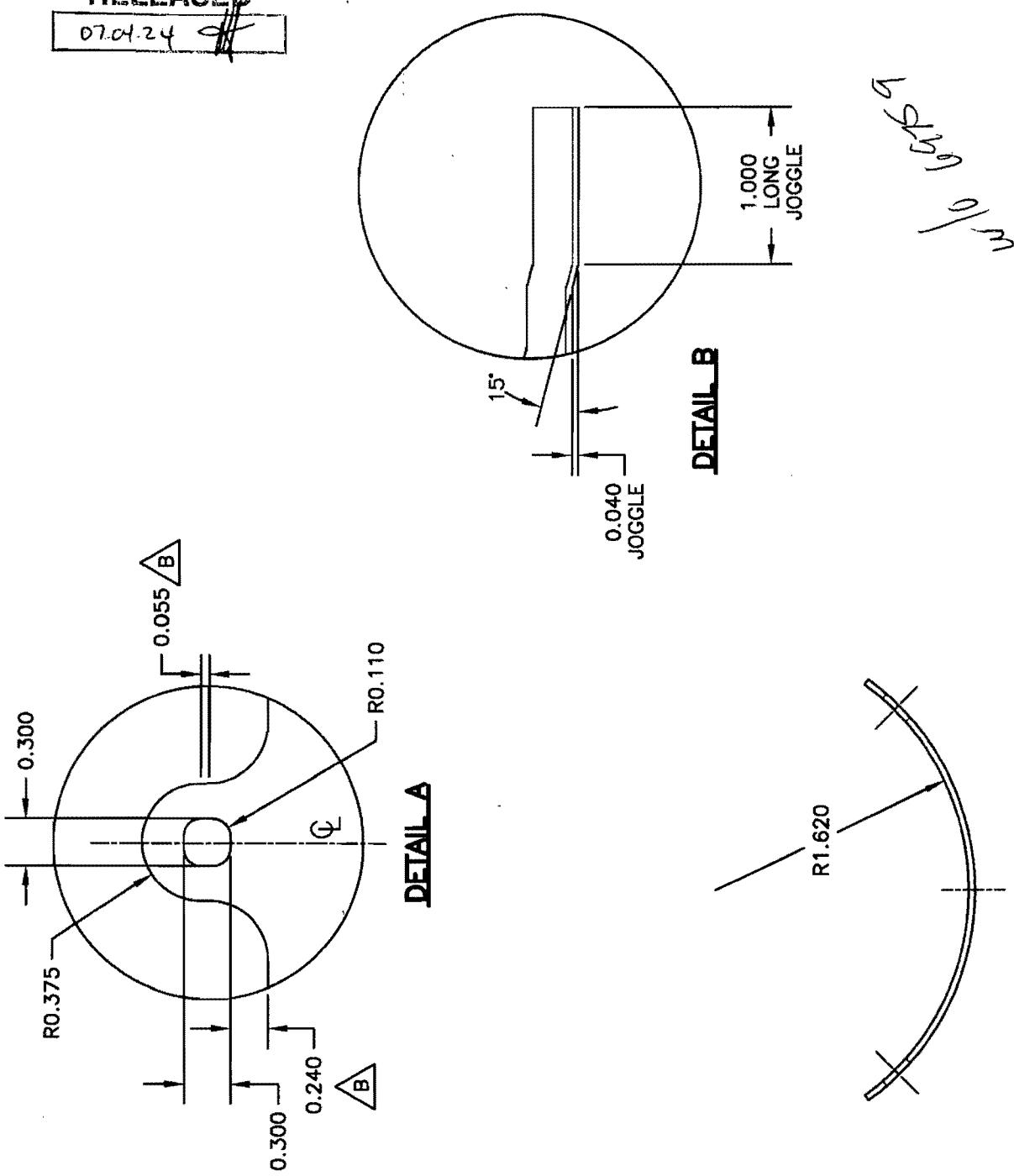
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

07.04.24 *[Signature]*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries